Date

Tuesday, 15/08/2006 7:17:40 AM

User:

Linda Lacelle

Process Sheet

Customer **Job Number**

: CU-DAR001 Dart Helicopters Services : 28162

Estimate Number

: 10517

P.O. Number

: NIA

This Issue Prsht Rev.

First Issue

: 15/08/2006

: NC

S.O. No. : NIA

: N/A

Previous Run Written By

Checked & Approved By

Comment

: 27285

Part now turned KJ/JLM

: MACHINED PARTS

Drawing Number

Material

Due Date

Drawing Name

Part Number

: D2806 REV A : N/A

: BUSHING

: D28061

Project Number Drawing Revision

AIL.

: 08/09/2006

Qtv:

30 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

M6061T6H1000

6061-T6 1" HexBar

Comment: Qty.:

0.0962 f(s)/Unit Total:

2.8854 f(s)

6061-T6 Hex Bar 1:0"

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.00" Hex Bar
(M6061T6H1 000) Batch: 9/00 720

2.0

1.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA105 and Dwg D2806

2-Tumble

30

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE



30

MILLING CONV



Comment: CONVENTIONAL MILLING MACHINE

Drill as per Dwg D2806

H://FORMS/Quality Assurance/apj

NOTE: Date & initial

06,09

62

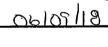
Dart	Aeros	pace	Ltd
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Dail AG	iospace L	itu							
W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cate	gory:					
NCR:		W	ORK ORD	ER NON-CONFORMA			sed:	Date: _	
NCK:			, -			· · · · · · · · · · · · · · · · · · ·	:	1 -	1
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Action Description Chief Eng	on B Sign Dat	& Se	fication ction C	Approval Chief Eng	Approval QC Inspector
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all entries

Date: Tuesday, 15/08/2006 7:17:40 AM User: Linda Lacelle **Process Sheet** Drawing Name: BUSHING Customer: CU-DAR001 Dart Helicopters Services Job Number: 28162 Part Number: D28061 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION 7.0 **Comment: INSPECT ALODINE** 8.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 57 DOCUMENT CONTROL 9.0 DC Comment: DOCUMENT CONTROL Inspection Level 21





Job Completion



U 0609.18

H. IFORINS (Quality Assurance) approved OAINCRINO REVD

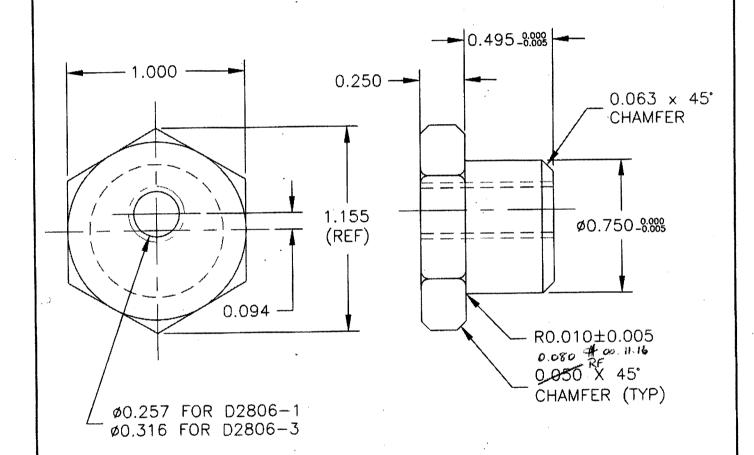
7			WC	ORK ORDER CHANGES	}				
		PR	OCEDURE CHA		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								-	
Part No	<u> </u>								L
	/·	PAR #:	Fault Cate	gory: I	ICR: Yes	No DQ	A:	_ Date: _	
					QA:	N/C Close		Date: _ Date: _	
NCR:				ER NON-CONFORMAN	QA:	N/C Close			
NCR:			WORK ORDI	ER NON-CONFORMANG Corrective Action Section E	QA: CE (NC	N/C Close R)	d:	_ Date: _	
	STEP		WORK ORDI	ER NON-CONFORMAN	QA: CE (NC	N/C Close R) Verific			
NCR:		Description of NC	WORK ORDI	ER NON-CONFORMANG Corrective Action Section E Action Description	QA: CE (NC	N/C Close R) Verific	d:	Date:	Approval
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NCR:		Description of NC	WORK ORDI	ER NON-CONFORMANG Corrective Action Section E Action Description	QA: CE (NC	N/C Close R) Verific	d:	Date:	Approval

• initial all entries





	DESIGN	f	ORAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
)	CHECKED	P	APPROVED	DRAWING NO. D2806 SHEET	REV. 1 OF	
	DATE		1 7/1	TITLE	SCA	LE
	00.11.	.08		BUSHING		2:1
Minne	Δ		00.11.08	NEW ISSUE		



D2806-1 (DRILL Ø0.257 HOLE) D2806-3 (DRILL Ø0.316 HOLE)

REFERENCE ONLT

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	28167
Description: Bushing	Part Number:	D2806-1
Inspection Dwg: D2806 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolciance	Dimension	Accept	Rojoot	Inspection	
1.000	+/-0.010	1,005	V			
1.155	+/-0.010	1,145				
0.250	+/-0.010	, 255			,	
0.063 x 45°	+/-0.010	.255 .063×45°				
0.080 x 45°	+/-0.010	.080 x45°				
0.495	+0.000/-0.005	,490				
0.750	+0.000/-0.005	.748			:-	
Ø0.257	+0.005/-0.000	1258				
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Measured by:	Audited by: 5.6	Prototype Approval:	N/A
Date: 06/09/1/	Date: 06/09/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.02.25	New Issue	KJ/RF	